

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008188**Date Inspected:** 23-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yu Dong Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Component: Tower components

Bridge No: 34-0006**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 6B,7B located on PCMK WSD1 FCSA4-4 A/D. Welder is identified as 040634. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-U3c-S-2

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1 FCSA4-2 A/C 84 A/B NA NA

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

2. WSD1 FCSEA4-2 A/C 85 A/B NA NA
3. WSD1 FCSEA4-2 A/C 86 A/B NA NA
4. WSD1 FCSEA4-2 A/C 28 A/B NA NA
5. WSD1 FCSEA4-2 A/C 29 A/B NA NA
6. WSD1 FCSEA4-2 A/C 30 A/B NA NA
7. NSD1 A166 J/J 23 NA NA
8. NSD1 A166 J/J 24 NA NA
9. NSD1 A166 J/J 19 NA NA
10. NSD1 A166 J/J 44 NA NA
11. NSD1 A166 J/J 9 NA NA
12. NSD1 A166 J/J 10 NA NA
13. NSD1 A166 J/J 5 NA NA
14. NSD1 A166 J/J 37 NA NA
15. NSD1 A112 H/H 8 NA NA
16. NSD1 A112 H/H 19 NA NA
17. NSD1 A112 H/H 3 NA NA
18. NSD1 A112 H/H 14 NA NA

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
----------------------	-------------------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------